

# Work Order ID 108584

\*108584\*

Page 1

October-23-13 7:37:45 AM

Item ID: D350-591-311

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Heli-Access-Step™ LH

Start Date: 10/23/13 Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 11/01/13 Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Approvals: Process Plan: 

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3272

Rev B

DAS

27

9-89

100

0.00

\*100\*

DC

Document Control

DOCUMENT CONTROL

Memo 

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

0.00

13 11.01

10

110

0.00

\*110\*

Large Fab

Large Fab

Large Fab

Memo

1-Bevel end for welding FWD ONLY ✓

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg ✓

D3272

A/RAluminum Rod M127165 / M125091

3-Grind End Plate flush

SAD

13-10-24

0.00

13-10-23

10

# Work Order ID 108584

\*108584\*

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October-23-13 7:37:45 AM

Item ID: D350-591-311

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\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Heli-Access-Step™ LH

Start Date: 10/23/13 Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 11/01/13 Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Run Start

\*NR1\*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

\*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

\*120\*

QC

Memo

0.00

Quality Control

10 0 13-07-24

130

QC5- Inspect part completeness to step on W/O

0.00

\*130\*

QC

Memo

0.00

Quality Control

DAS  
27  
9-89

131024

10

140

Chemical Conversion Coat per QSI005 4.1

0.00

\*140\*

HandFinish

Memo

0.00

Hand Finishing

10 2613-10-26

# Work Order ID 108584

**\*108584\***

Page 3

October-23-13 7:37:45 AM

Item ID: D350-591-311

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Heli-Access-Step™ LH

Start Date: 10/23/13 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 11/01/13 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

**\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC7-Inspect Chemical Conversion Coat	0.00				10	d		DAS 19 9-89 13-10-29
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									
180		0.00							
<b>*180*</b>									
Large Fab	Large Fab	0.00				10			DAS 19 9-89 13-10-29
Large Fab	Memo	0.00							
	1-Assemble Leg Assembly as per Dwg D3272.								SAD 13-10-29
	2-Leave one rivet out until welding is complete.								
	3-Bevel Aft end for welding								
	4-Inspect for foreign object as per QSI 024								11/13-10-29
	5-Weld Aft End Plate as per QSI 004 & Dwg D3272								
	A/RAluminum Rod 123928								
	6-Grind End Plate flush								SAD 13-10-29
	7-Install last rivet as per Dwg								

**Work Order ID 108584****\*108584\***

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October-23-13 7:37:45 AM

Item ID: D350-591-311

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Heli-Access-Step™ LH

Start Date: 10/23/13 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 11/01/13 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC10- Inspect visual per QSI004- ground welds	0.00							
<b>*190*</b>									
QC	Memo	0.00							
Quality Control									
200	QC5- Inspect part completeness to step on W/O	0.00							
<b>*200*</b>									
QC	Memo	0.00							
Quality Control									
210	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*210*</b>									
HandFinish	Memo	0.00							
Hand Finishing									

DAS  
9  
9-89DAS  
9  
9-89

10 767 13-10-30

# Work Order ID 108584

\*108584\*

Page 5

October-23-13 7:37:45 AM

Item ID: D350-591-311

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Heli-Access-Step™ LH

Start Date: 10/23/13 Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 11/01/13 Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Run Start

\*NR1\*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

\*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

220

White Gloss(Ref 4.3.5.1) per QSI005 4.3-Alum

0.00

\*220\*

Powdercoat

Powder Coating

Memo

0.00

START TIME

OVEN TEMPERATURE

FINISH TIME

10 0 B-10-31.

DAS  
34  
9-89

230

Wing Walk as per dwg QSI005 4.4 Batch M 127106

0.00

\*230\*

HandFinish

Hand Finishing

Memo

1064 f 11 13/10/31

240

QC3- Inspect Part Finish

0.00

\*240\*

QC

Quality Control

Memo

0.00

10 (DAS 25) 13.11.01

# Work Order ID 108584

**\*108584\***

Page 6

October-23-13 7:37:45 AM

Item ID: D350-591-311

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Heli-Access-Step™ LH

Start Date: 10/23/13 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 11/01/13 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00			DAS 3 9-89	10x	DAS 28 9-89	13-10-31	
<b>*250*</b>									
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00			DAS 27 9-89	10			
<b>*260*</b>									
QC	Memo	0.00							
Quality Control									
270		0.00							
<b>*270*</b>									
Packaging	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-591-311								
	Location: <u>Fail</u>								

**Work Order ID 108584****\*108584\***

Page 7

October-23-13 7:37:45 AM

Item ID: D350-591-311

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Heli-Access-Step™ LH

Start Date: 10/23/13 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 11/01/13 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

280

QC21- Final Inspection - Work Order Release

0.00

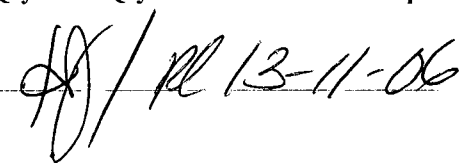
**\*280\***

QC

Memo

0.00

Quality Control



# Picklist Print

October-23-13 7:37:42 AM

Page 1

Work Order ID: 108584

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step™ LH

Start Date: 10/23/13

Required Date: 11/01/13

Start Qty: 10.00

Required Qty: 10.00

## Comments:

IPP Rev:A04.03.22New issue KJ/RF

IPP Rev:B 07-06-09 Added D3272-1 JLM

IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC

IPP Rev:D fixe

route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3272-1 Step		Manufactured	No		B104220	110	Each	14.0000	1	10		13-10-23	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA003		14							
				105475		7							
				105476		7							
D3067-1 End Plate		Manufactured	No			110	Each	380.0000	1	10		13-10-23 PD	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA003		380				10			
				01785		189							
				102686		165							
				67582		2							
				68214		1							
				78608		4							
				79607		1							
				83855		1							
				90178		1							
				90486		3							
				95930		4							
				96228		9							



# Picklist Print

October-23-13 7:37:43 AM

Work Order ID: 108584  
 Parent Item: D350-591-311  
 Parent Item Name: Heli-Access-Step™ LH

Start Date: 10/23/13  
 Start Qty: 10.00

Required Date: 11/01/13  
 Required Qty: 10.00

D3219-1 Manufactured No  
 Plate

110 Each 244.0000 2 20

(20) 13.10.23 PD

Location	Loc Qty	Loc Code
ST	144	
101508	144	
WA003	100	
101870	40	20
73410	12	
77674	6	
89967	2	
96128	40	

D3066-1 Manufactured No  
 Spacer

180 Each 164.0000 2 20

13.10.31

Location	Loc Qty	Loc Code
WA003	164	
107436	160	20
95963	4	

MS20600-AD4W4 Purchased No  
 Rivets

180 Each 4,760.0000 16 160

13.10.31

Location	Loc Qty	Loc Code
ST	3870	
125577	3870	160
ST311	374	
123900	350	
125406	24	
ST506	516	
125654	516	

D3065-041 Manufactured No  
 Step Leg Assembly

180 Each 35.0000 1 10

13.10.31

Location	Loc Qty	Loc Code
WA003	35	
103486	34	10
79336	1	

# Picklist Print

October-23-13 7:37:43 AM

Work Order ID: 108584

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step™ LH

Start Date: 10/23/13

Required Date: 11/01/13

Start Qty: 10.00

Required Qty: 10.00

D3067-1 Manufactured No  
End Plate

180 Each 380.0000 1 10

*13-10-31*

Location	Loc Qty	Loc Code
WA003	380	
101785	189	
102686	165	
67582	2	
68214	1	
78608	4	
79607	1	
83855	1	
90178	1	
90486	3	
95930	4	
96228	9	

*10*

Purchased No

250 Each 125.0000 20

*DAS 13-10-31*  
*28*  
*9-89*

Location	Loc Qty	Loc Code
FG	10	
122800	10	
ST352	15	
125211	4	
m126400	11	
ST512	100	
m126765	100	

*11X*

*9X*

Manufactured No

250 Each 207.0000 20

*DAS*  
*28*  
*9-89*

Location	Loc Qty	Loc Code
ST466	44	
102818	44	
ST470	163	
101559	160	
90002	2	
99256	1	

*20X*

AN3-35A  
Bolt

DAS  
27  
9-89

*10X*

D3235-1  
Mounting Lug

DAS  
27  
9-89

*10X*

# Picklist Print

October-23-13 7:37:43 AM

Page 4

Work Order ID: 108584

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step™ LH

Start Date: 10/23/13

Required Date: 11/01/13

Start Qty: 10.00

Required Qty: 10.00

D3278-041

Manufactured No

250

Each

71.0000

10

DAS  
28  
9-89

13-10-31

Support Assembly

## Location

## Loc Qty

## Loc Code

ST466 30  
102774 30  
ST470 41  
102349 40  
90706 1

DAS  
27  
9-89

10X

10X

NAS1149D0463J

WASHER

Purchased No

250

Each

2,283.0000

16

160

DAS  
28  
9-89

## Location

## Loc Qty

## Loc Code

FP001 2  
122441 2  
ST007 24  
121912 24  
ST294 135  
119097 1  
124198 35  
124778 99

DAS  
27  
9-89

10X

ST510a 2122  
M126221 2122

DAS  
6  
9-89

160X

NAS1149D0563J

Washer

Purchased No

250

Each

5,202.0000

4

40

DAS  
28  
9-89

## Location

## Loc Qty

## Loc Code

ST294 111  
123248 42  
123355 12  
m125807 57  
ST298 91  
122452 91  
ST510a 5000  
m126319 5000

DAS  
27  
9-89

10X

40X

October-23-13 7:37:44 AM

Shop Packet Print

Page 4

# Picklist Print

October-23-13 7:37:44 AM

Page 5

Work Order ID: 108584

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step™ LH

Start Date: 10/23/13

Required Date: 11/01/13

Start Qty: 10.00

Required Qty: 10.00

ANS-36A- Bolt Purchased No 250 Each 175.0000 2 20 DAS 28 9-89 13-10-31

DAS  
27  
9-89

10X

## Location

## Loc Qty

## Loc Code

ST338 172  
123525 1  
M126105 171  
ST517 3  
125388 3

20X

D2618- Bushing

Manufactured No

250 Each 492.0000 2 20

DAS  
28  
9-89

DAS  
27  
9-89

10X

## Location

## Loc Qty

## Loc Code

ST013 492  
101708 97  
102964 100  
103863 113  
105836 57  
89275 1  
97780 124

20X

D2230-3

Mounting Lug

Manufactured No

250 Each 300.0000 4 40

DAS  
28  
9-89

DAS  
27  
9-89

10X

## Location

## Loc Qty

## Loc Code

FG 4  
89045 4  
ST469 296  
101450 4  
101495 4  
101911 160  
102326 100  
89782 19  
90514 1  
94957 4  
97815 2  
97903 2

40X

October-23-13 7:37:44 AM

Shop Packet Print

Page 5

# Picklist Print

October-23-13 7:37:44 AM

Work Order ID: 108584

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step™ LH

Start Date: 10/23/13

Required Date: 11/01/13

Start Qty: 10.00

Required Qty: 10.00

D2856-400 Manufactured No

250 f

204.3992

12

12

DAS  
28  
9-89

13-10-31

Abrasion Strip 4" Wide (Per-Foot) →

\*\*\* cut (2) at 7.20" (D2856-400-720) \*\*\*

## Location

## Loc Qty

## Loc Code

ST408

162.9252632

101773

157.56

99378

5.36526316

ST415

41.4739

63735

0.6696

68076

0.3149

71164

8.46

81875

6.398

86905

0.9569

89352

24.6745

DAS  
27  
9-89

10X

12X

DAS  
6  
9-89

DAS  
28  
9-89

MS21042L3

Nut

Purchased

No

250

Each

4,258.0000

2

20

## Location

## Loc Qty

## Loc Code

ST314

35

M126036

35

ST506

821

123900

821

ST510a

3402

M126333

3402

DAS  
27  
9-89

10X

DAS  
6  
9-89

20X

DAS  
28  
9-89

AN4-13A

Bolt

Purchased

No

250

Each

1,431.0000

80

80

## Location

## Loc Qty

## Loc Code

FG

20

122808

20

ST511

1000

m126193

1000

ST514

411

m125709

411

DAS  
27  
9-89

10X

80X

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Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step™ LH

Start Date: 10/23/13

Required Date: 11/01/13

Start Qty: 10.00

Required Qty: 10.00

MS21042L5  
Nut

Purchased No

250 Each

826.0000

DAS 6 9-89

2

20

DAS 28 9-89

13-10-31

DAS 27 9-89

10X

Location

Loc Qty

Loc Code

st507

826

125535

826

Purchased

No

250 Each

2,738.0000

DAS 6 9-89

8

80

DAS 28 9-89

20X

Location

Loc Qty

Loc Code

FP001

50

122452

38

8182

12

ST314

9

m125708

9

st507

33

m126073

33

ST509

2230

m126275

2230

ST510a

258

m126333

258

ST518

158

124231

158

80X

DAS 27 9-89

10X

NAS1149D0363J  
Washer

Purchased

No

250 Each

5,717.0000

DAS 6 9-89

4

40

DAS 28 9-89

DAS 27 9-89

10X

Location

Loc Qty

Loc Code

FP001

1

123248

1

ST294

251

113068

11

124392

240

ST510a

5465

m126319

5465

40X



DESIGN <i>9P</i>	DRAWN BY <i>JB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

**RELEASED**

07.06.04 *[Signature]*



QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

**GENERAL NOTES:**

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

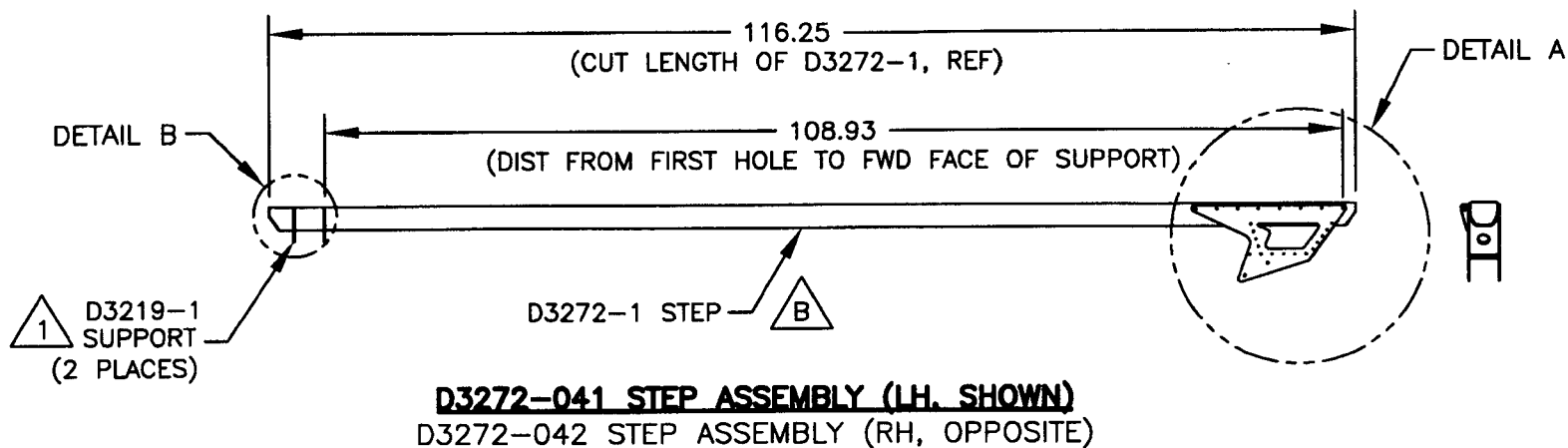
*2/06/04*

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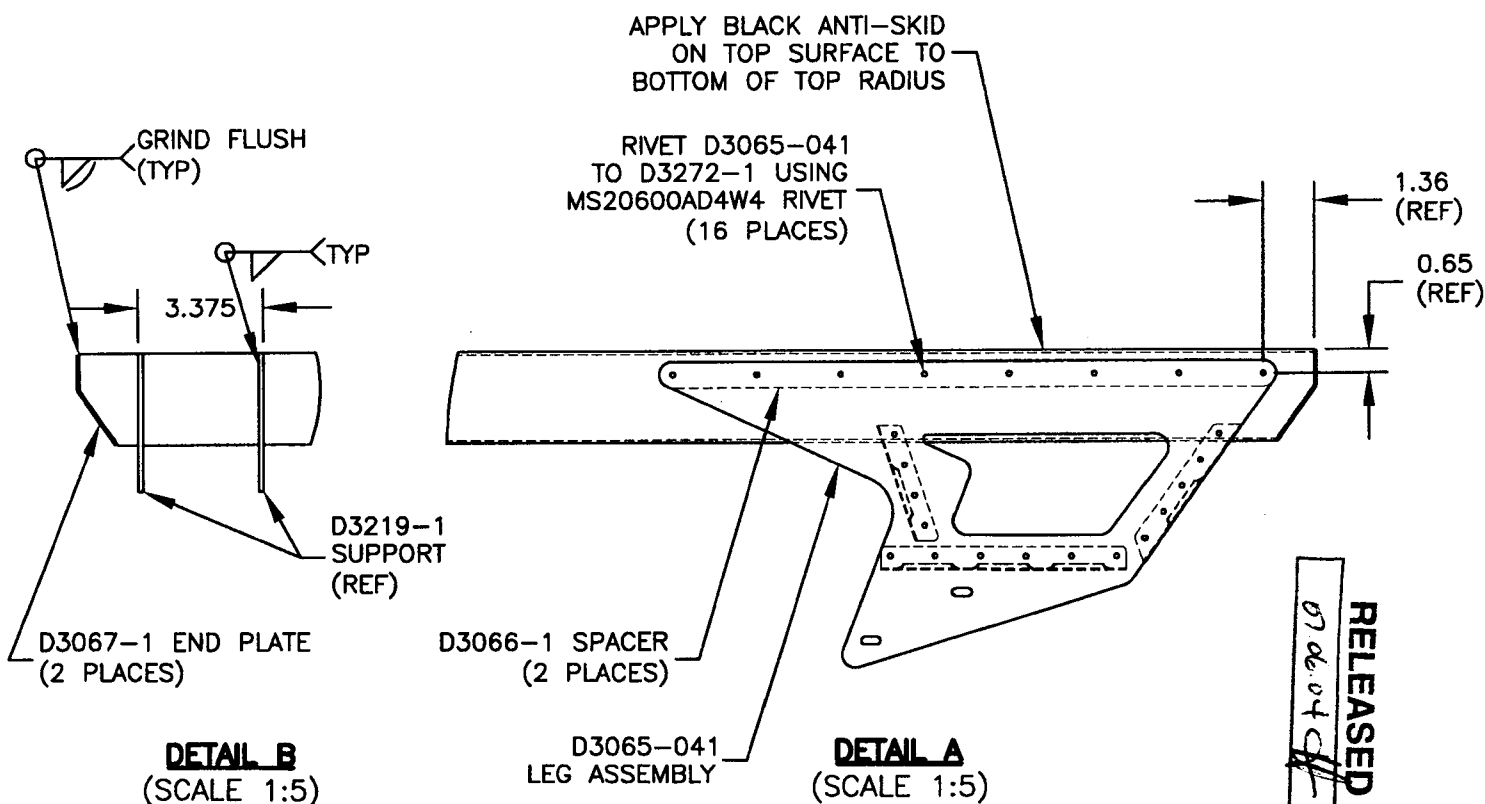
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**DART**

DESIGN	qo	DRAWN BY	JB	<b>DART AEROSPACE LTD</b>
CHECKED	Le	APPROVED	JB	HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	DRAWING NO.	D3272	REV. B
		TITLE	STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
				SCALE 1:20



**D3272-041 STEP ASSEMBLY (LH. SHOWN)**  
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



RELEASED  
07.06.04

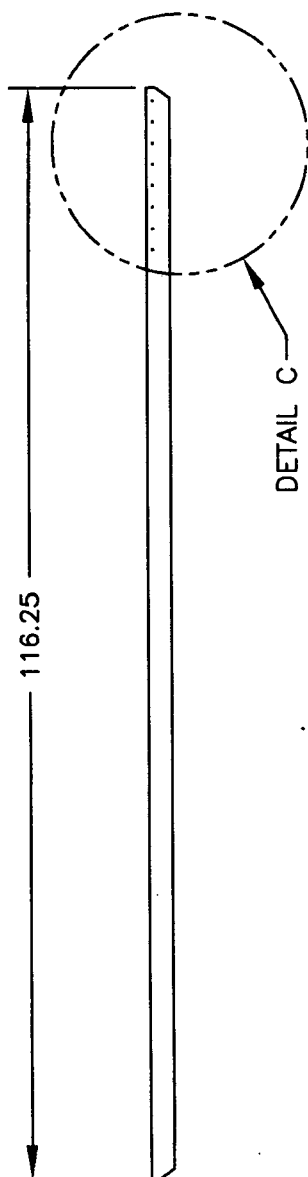




DESIGN <i>qp</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

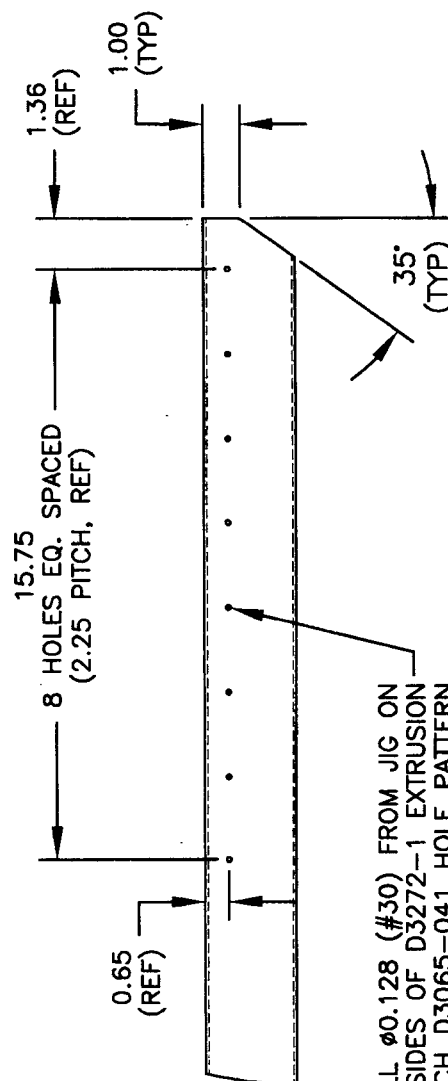
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07.06.04 *[Signature]*



DETAIL C

**B D3272-1 STEP**  
(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL  $\phi 0.128$  (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

**DETAIL C**  
(SCALE 1:5)

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Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<b>Heli-Access-Step™</b> , Long Step – High Skid, LH
	X							D350-591-212	<b>Heli-Access-Step™</b> , Long Step – High Skid, RH
		X						D350-591-213	<b>Heli-Access-Step™</b> , Short Step – High Skid, LH
			X					D350-591-214	<b>Heli-Access-Step™</b> , Short Step – High Skid, RH
				X				D350-591-215	<b>Heli-Access-Step™</b> , Short Step – Low Skid, LH
					X			D350-591-216	<b>Heli-Access-Step™</b> , Short Step – Low Skid, RH
						X		D350-591-311	<b>Heli-Access-Step™</b> , Long Step – High Skid, LH
							X	D350-591-312	<b>Heli-Access-Step™</b> , Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

\*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

Work Order ID 108584

\*108584\*

Page 1

October-23-13 7:37:45 AM

Item ID: D350-591-311

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Heli-Access-Step™ LH

Start Date: 10/23/13 Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 11/01/13 Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Run Start \*NR1\*

Approvals: Process Plan: 

Date:

Tooling:

Date:

Stop \*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3272	Rev B
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100		0.00							
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\*100\*

DC

Document Control

DOCUMENT CONTROL

Memo 

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

0.00

110

\*110\*

Large Fab

Large Fab

Large Fab

Memo

1-Bevel end for welding FWD ONLY ✓

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg ✓

D3272

A/RAluminum Rod M27165 / M125091

3-Grind End Plate flush

SAD

13-10-24

0.00

0.00

MCS 13-10-31

10

13-10-23